

# Work Order ID 63215

Monday, October 25, 2010 12:35:10 PM



Page 1

Item ID: D212-725-1-085F

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:   N  

Date: 10/10/25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024 .050

1-Cut as per Dwg

Dwg Rev: F

Prog Rev: F

2-Deburr if necessary

1310-10-27

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1310-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

See Attached E-mail  
no helix here bke  
Done @ Eng.

10/27/27

(x)

130

Bend as per dwg

0.00



Brake NC

Brake NC

Memo

AND FORM JOGGLE AS PER DWG

0.00

SB 10/10/28

(4)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

10/10/28

(x)

W/O:		WORK ORDER CHANGES					
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Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4		28/10/10-28	
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	741	10/10/28		4	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: 384  Memo	0.00  0.00							4/4/28 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 4

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Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 10/25/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 JF  
MF  
10-10-28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, October 25, 2010 12:35:14 PM

Page 1

Work Order ID: 63215



Parent Item: D212-725-1-085F



Parent Item Name: Bracket

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: JPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

106.8847

0.07732

0.325558



BIG-10-27

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

106.8847

111381

11.89

113189

0.3947

114968

94.6

114968

B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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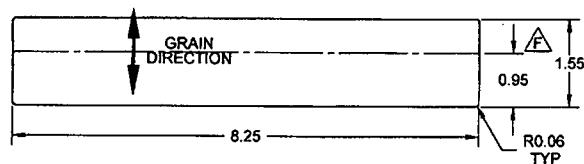
**NOTE:** Date & initial all entries

D212-725-1-085F

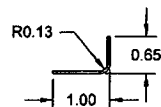
☒ **First Article**    ☐ **Prototype**

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-27	Date:	10/10/27	Date:	N/A

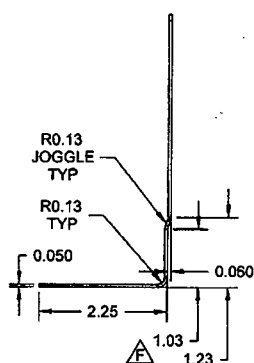
H:\FORMS\Quality Assurance\approved QA\FAI revD



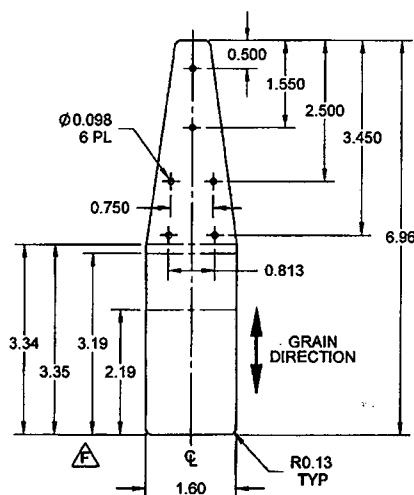
**D212-725-1-107F FLAT PATTERN**



**D212-725-1-107 ANGLE**  
(MAKE FROM D212-725-1-107F FLAT PATTERN)



**D212-725-1-085 BRACKET**  
(MAKE FROM D212-725-1-085F FLAT PATTERN)



**D212-725-1-085F FLAT PATTERN**

**D212-725-1-085 NOTE:**

1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.050)

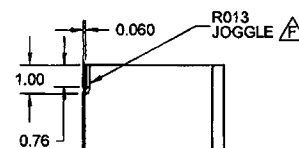
**D212-725-1-107 NOTE:**

2) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037  
(FER. DART SPEC. M2024T3S.040)

**GENERAL NOTES:**

- 3) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541, AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

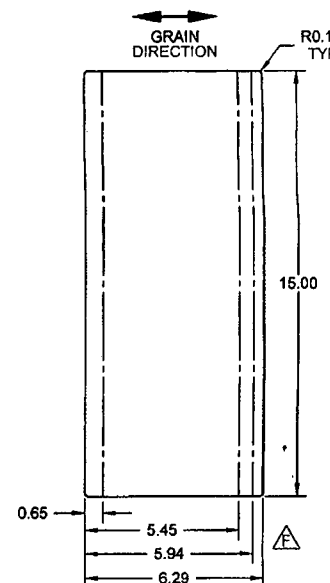
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63215



**D212-725-1-083 SHELF SPLICE**  
**D212-725-1-084 OPPOSITE**  
(MAKE FROM D212-725-1-083F FLAT PATTERN)




**D212-725-1-083/084 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4  
(REF. DART SPEC. M2024T3S.050)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



**D212-725-1-083F FLAT PATTERN**

RELEASED  
09/04/07 JMB

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 32 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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2810-1025

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**L Lacelle**

**From:** Robert Fuentes [rfuentes@dartaero.com]

**Sent:** October 27, 2010 1:03 PM

**To:** 'L Lacelle'

**Cc:** 'H. Siemens'; 'David Shepherd'

**Subject:** RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

**From:** L Lacelle [mailto:llacelle@dartaero.com]

**Sent:** Wednesday, October 27, 2010 9:47 AM

**To:** 'Robert Fuentes'

**Cc:** 'H. Siemens'; 'David Shepherd'

**Subject:** FW:

Roberto,

I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is... what is your preference?

Please next time let someone know that the dwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

**From:** David Duval [mailto:dduval@dartaero.com]

**Sent:** October 27, 2010 11:43 AM

**To:** Linda Lacelle

**Subject:**

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

**David Duval**

*Production Engineering Coordinator*



1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel: (613) 632-5200

[dduval@dartaero.com](mailto:dduval@dartaero.com)



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10/27/10